

5259244



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D5799-7

Job Sheet 207426

NO 20.02.20



Part No: D5799-7

Job Qty: 8 pcs

Part Name: Lever



Part Weight: 0 lbs

Job Created: 2/26/20

Due Date: 3/6/20

Type: Stock

Status: New

Job Tracking No:

Created By: Jennifer Renwick

Description:

POSITIVE RECALL

EFFECTIVE \_\_\_\_\_

RELEASED \_\_\_\_\_

Placed by mistake  
NO 20.02.20

Priority: Medium

Note: URF 2020-525 DWG 5799 REV.A IPP REV:A NEW ISSUE 20.01.15 JV VERF:DD

Ship Via:

## Bill of Materials

## Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs	3/6/20	3/6/20	0.17	0.33	Waterjet - Flow		20.02.20
110	QC 2	8 pcs	3/6/20	3/6/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20.02.20
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

PRIORITY

Plex 2/26/20 9:58 AM Dart.lajeunesse.marie



120 QC 8	8 pcs	3/6/20	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Packaging 3-1 - Stock - B4B	8 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	

DAS

FEB 28 2020 4:00 PM

8-89

MFC

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	8 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1-Cut as per D5799-7 DWG. DWG. Rev: A PROG. Rev: A 2-Debur if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Identify as per dwg & Stock Location: \_\_\_\_\_

140 - QC21- Final Inspection - Work Order Release

FEB 28 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	6.0096 s' (.7512 ea)	100-Waterjet - Flow - 1	5242860

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	6	144	0

Part Specifications	
Specifications could not be found.	

Plex 2/26/20 9:58 AM Dart.lajeunesse.marie





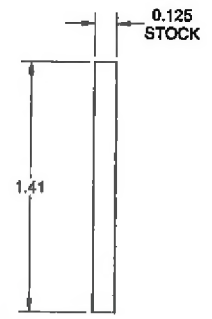
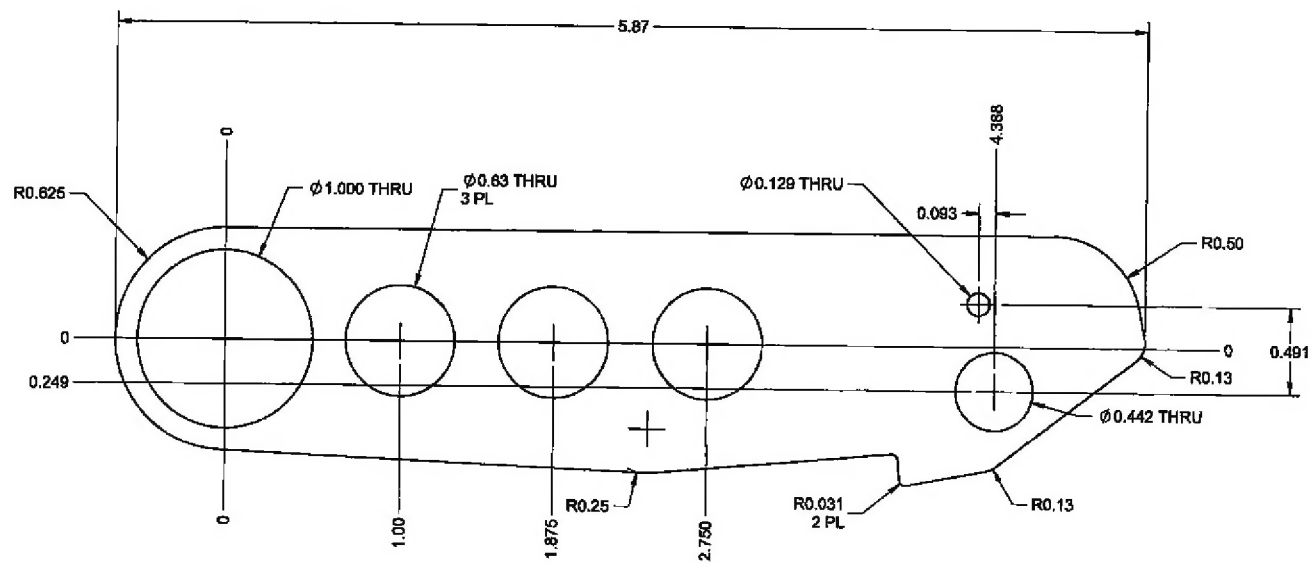
8 7 6 5 4 3 2 1

D

C

B

A



**D5799-7 LEVER**  
(DERIVED FROM AERO DESIGN P/N 84265-01)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 207426 M15  
20-02-26

UNDER REVIEW

URF 2020-525 20.02.20 (NO)

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED, #11 GA (0.125 THICK)  
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.006 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs
- 8) ALL NON-DIMENSIONED FEATURES TO BE WITHIN 0.030 OF 'D5799-7-REVA.DXF'

**RELEASED**  
2020 FEB 19<sup>th</sup>

APPROVED

DESIGN ZF  
DRAWN ZF  
CHECKED KPT  
MFG. APPR. DD  
APPROVED NO  
DE APPR. CP  
DATE 20.01.10

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
DRAWING NO. **D5799**  
TITLE **HANDLE**  
REV. A  
SHEET 3 OF 4  
SCALE  
NTS  
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8 7 6 5 4 3 2 1






Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K8A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER POHB045332



Items													
Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3		M0061T6S.080			6061-T6 .080 Sheet  MATERIAL: 6061- T6/T62 ALUMINUM SHEET AS PER QQ-A- 250/11 OR AMS-QQ-A- 250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 receive of	Firmed		12/13/19	192 sf	0 sf	192 sf	\$6.2664583/sf	\$1,203.16
												DAS 82 9-89  DEC 19 2019	
4		M304S11GA			304/316 0.125 Sheet  MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240	Firmed		12/13/19	96 sf	0 sf	96 sf	\$13.329082/sf	\$1,279.59
												DAS 82 9-89  DEC 19 2019	
5		M304S14GA			304SS sheet .080  MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 receive of	Firmed		12/13/19	64 sf	0 sf	64 sf	\$8.366652830/sf	\$535.47
												DAS 82 9-89  DEC 19 2019	



# ACIER OUELLETTE INC.

935, Blvd. du Hiver  
 Valleyfield (Quebec) J6S 5L1  
 TEL: 450-377-4240 Mtl: 514-336-4240 Ext.: 800-667-4348  
 Fax: 450-377-5608 Mtl: 514-336-4246 Ext.: 800-455-4342

## DELIVERY - \*\*MILL TEST\*\*

Copy

C000183417

### Shipped to

DART AEROSPACE LTD

1370, APERLEEN ST.  
 MANKESOURY, Ontario, K6A 1K7

### Shipped to

1270, ABERDEEN ST.  
 MANKESOURY, Ontario, K6A 1K7

Alt :

Delivery Route 5

### Customer N°

Date

Delivery date

Your order N°

Processed by

Salesman

Carrier

Credit Terms

C10001056

2019/12/05

2019/12/13

POHE045332

Josianne Boudon

JOSIANNE BOURDON

OUELLETTE VALLEYFIELD

Net 30 Days

Instruction : F-M

Product Description	Weight	Qty	UO	PCS NB			Internal Use Only				
				CND	EXP	B/O	IN	I	S	C	OUT
1 ALU SHEET .040 (18G) 2024-T3 Q8 (4 X 12) DART FEALD-0304120213 12473 AC32236-SA-11/12 Lot 33898839 cont: 131	31.07	144.00	PI2_QCLB								
2 ALU SHEET 3/16 6061-T6 (4 X 12) FEAL-3154125001 1260 AC32273-TH-11/12 Lot 16135/1 H: 01/09/1979/8	128.85	96.00	PI2_QCLB								
3 ALU SHEET .061 (12G) 6061-T6 (4 X 12) FEAL-0914120061 3195 TRANSPORT ST-JEROME LE 11-12 PACKAGING Lot: 400871 H: H3600221	164.37	144.00	PI2_QCLB								
4 SHEET SS 11G SS304-2B (4 X 8) FESS-11G483042B 3002 PACKAGING Heat: C84X	594.00	96.00	PI2_QCLB								
5 SHEET SS 14G SS304-2B (4 X 8) FESS-14G483042B 3412 PACKAGING Heat: L7354C10	209.00	64.00	PI2_QCLB								
6 SHEET SS 16G SS304-2B (4 X 8) FESS-16G483042B 3419 PACKAGING Heat: 4167	326.00	128.00	PI2_QCLB								
7 SHEET SS 18G SS304-2B (4 X 8) FESS-18G483042B 3425 PACKAGING Heat: C44B	672.00	320.00	PI2_QCLB								

DEC 28 2019

LINE 4

## MATERIAL RECEIPT INSPECTION FORM

MATERIAL M304S 116A  
 DATE DEC 20 2019

PO / BATCH NO: POM304S 332  
S 242860

MATERIAL CERT REC'D YES  
 QUANTITY RECEIVED 96 SF  
 QUANTITY INSPECTED 96 SF  
 QUANTITY REJECTED           

THICKNESS ORDERED .125  
 THICKNESS RECEIVED .125  
 SHEET SIZE ORDERED 4' x 8'  
 SHEET SIZE RECEIVED 4' x 8'

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	
CORRECT FINISH	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	
CORROSION	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	
CORRECT GRAIN DIRECTION	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	
CORRECT MATERIAL PER D-DRAWING	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	<u>ASTM A240</u>
CORRECT THICKNESS	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	
PHOTO REQUIRED	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	
CORRECT REF # TO LINK CERT	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	<u>KIT COPY</u>
CORRECT MATERIAL IDENTIFICATION	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	
CORRECT M# ON THE MATERIAL	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	
DOES THIS REQUIRE AN EXTRUSION REPORT	<input checked="" type="checkbox"/> Y	<input checked="" type="checkbox"/> N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

*Tests located in the Quality Office*

QC 15 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>32</u>	SIGNED OFF BY: _____		
DATE: <u>DEC 20 2019</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



LIVE 4

M304S11GA

# SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: 304/316 SS SHEET  
ANNEALED

SPECIFICATION: MS-4250  
OR AMS 5613 (204)  
OR AMS 5613 (316)  
OR ASTM A240  
OR ASME SA240

DAS  
82  
8-89

FINISH

FINISH IDENTIFIER  
UNPOLISHED No. 1  
UNPOLISHED No. 20  
UNPOLISHED No. 25  
POLISHED No. 3  
POLISHED No. 4  
BUFFED No. 6  
BUFFED No. 7  
BUFFED No. 8

DEC 20 2010

PART NUMBER: M304S11GA GP  
'GA'

WHERE 'T' = GAUGE THICKNESS  
WHERE 'P' = FINISH IDENTIFIER

EO 16 GAUGE SS SHEET 20 FINISH = M304S11GA  
FG 16 GAUGE SS SHEET No. 4 POLISHED = M304S11GA-P

## GAUGE THICKNESS REFERENCE

GAUGE	NOM THICK. (IN)	THICKNESS RANGE (IN)
26	0.01875	0.0175 - 0.019
25	0.021875	0.0206 - 0.023
24	0.025	0.0236 - 0.026
23	0.028125	0.0267 - 0.029
22	0.03125	0.0298 - 0.033
21	0.034375	0.0329 - 0.036
20	0.0375	0.0360 - 0.040
19	0.04375	0.0411 - 0.046
18	0.050	0.0472 - 0.052
17	0.05625	0.0533 - 0.059
16	0.0625	0.0594 - 0.066
15	0.0703125	0.0665 - 0.073
14	0.078125	0.0746 - 0.081
13	0.086875	0.0839 - 0.091
12	0.100375	0.0979 - 0.106
11	0.125	0.1195 - 0.130
10	0.140625	0.1331 - 0.146
9	0.15625	0.1488 - 0.160
8	0.171875	0.1641 - 0.176
7	0.1875	0.1802 - 0.194
6	0.2031	0.1959 - 0.212
5	0.2188	0.2091 - 0.228
4	0.2344	0.2245 - 0.244
3	0.2500	0.2398 - 0.260
2	0.2656	0.2554 - 0.276
1	0.2813	0.2711 - 0.293
0	0.3125	0.3011 - 0.325

RELEASED

206 FEB 04

Rev 10-12-04

REV	DESCRIPTION	BY	DATE
1	304/316 SS SHEET	AS	01-01-00
2	REVISED DARTWORK OPTION FOR CUS AND FRAMES OF PARTS FOR PARTS IDENTIFIED BY DARTWORK	MS	11-01-00
3	REVISED DARTWORK AND ASSEMBLY IDENTIFICATION OF DARTWORK FOR 16 GAUGE SS SHEET	GP	01-01-01
4	NEW PART	DS	01-01-04
DESIGN	DS	DART AEROSPACE LTD	
ENGINEER	AS	MANUFACTURED IN ONTARIO, CANADA	
CHANGED	AS	REV D	
MS APPRO	14	M304S	SHEET 1 OF 1
APPROVED	14	FILE	SCALE
MS APPRO	14	304/316 SS SHEET	NOTE
DATE	15 01 06	DART AEROSPACE LTD	

(J)

3402

FESS-11G483042B

S11304L

29638

70546

54988



North American Stainless Canada Inc.  
740 Imperial Road North  
Guelph, ON N1K1Z3  
Canada

# METALLURGICAL TEST REPORT

6870 Highway 42 East  
Ghent, KY 41045-9615  
(502) 347-6000

Certificate: 526418 1

Customer: 007050 001

Date: 7/25/2019 Page: 1

Steel: 304/304L

Finish: 2B

Corrosion: ASTM A262/15A; 180Bend-OK

Your Order: 70546

NAS Order: NW 0111468 02

## PRODUCT DESCRIPTION

STAINLESS STEEL COIL, C.R. ANNEALED & PICKLED. UNS 30430/30403  
ASTM A240/18, A480/10a, A566/15, A568 SN240/17, SA480/17, SA666/17  
CHECK ONLY ON FOLLOWING ASTM: A276/17, A479/17, A484/16, A312/16  
CHECK ONLY ON FOLLOWING ASTM: SA312/13, SA479/13  
ASTM A511H/5513V NOTE: MIL-8059D SPD3(X CHE REAS); MIL-40438  
ECCS MRO175/ISO 15156-2:2009 A, MRO103/97; Q3876SD-A X HAS FROM  
MIL SOLUTION STEEL TEMP 19007, WATER QUENCHED

## REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.  
EN 10204:2004 3.1; RoHS 1 & 2 compliant  
Material is Free of Radioactive Contamination  
Steel Making Process: EAF, AOD, & Cont. Casting  
Product Mfg. by a Quality Mfg. Sys. in Conf. w/ISO 9001  
\*Sourced & Manufactured in the USA; Mat'l is DPMs Compliant

82 DEC 20 2019

9-00

Product Id	Coil #	Skid # Thickness	Width	Weight	Length	Mark	Placed	Commodity Code
05C84X AA	05C84X A	.1200	48.0800	4,442 SHEETS	144.00	19		

## CHEMICAL ANALYSIS

CH(Country of Origin) ES(Spain) US(United States) ZA(South Africa) JP(Japan)

ANAL. ISO/IEC 17025, Certificate# L2323

Chemical Analysis per ASTM A751/14a

HEAT	CH	C %	CR %	CU %	FE %	ED %	N %	NI %	P %	S %
C84X	US	.0232	18.1453	.4395	1.8189	.3816	.0626	8.0790	.0320	.0033
SI %										
.3745										

## MECHANICAL PROPERTIES

Product Id#	1/4 x 1/2 x 3/4	UTS	20C .2% YS	20C ELONG	% Hard	Ball Hard
05C84X AA	F T	93.43	40.50	48.77	95.00	85.50

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical  
Dept. Mgr.

KRIS TARK

209099

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
<b>Root Cause</b>  <div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		<b>FAULT CATEGORY</b>  <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>			
Other/Details:					